



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D2873-043
Job Sheet 208451



Part No: D2873-043

Job Qty: 50 pcs **47**

DAS
21
9-59

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	50 pcs		4/13/20	0.00	0.24	Bandsaw - 1		J.C.L. 20-03-26
110	HAAS 4 Axis - B4B	50 pcs		4/13/20	0.04	13.19	HAAS - 1 - B4B		J.C.L. 20-03-26
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	50 pcs		4/13/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.L. 20-03-26
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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Container No: S266469



Part: D2873-043

Job No: 208451

Serial No/Batch: S266469

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/26/20

Plex 3/20/20 8:34 AM Dart.lajeunesse.marie

					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
130	QC 8	50 pcs	4/13/20	0.00 0.00	QC 8 - 12	20/03/29
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
150	QC 5	50 pcs	4/13/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Handfinish - 1-1 Chemical-	50	4/13/20	0.00 0.63	Handfinish - 1 - 1 - B4B	20-03-31

B4B	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170 QC 7	50 pcs	4/13/20	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	SMD
					QC 7 - 59	2014/1
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
180 Small Fab - 2 - B4B	50 pcs	4/13/20	0.00	1.70	Small Fab - 1 - B4B	SMD
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	2014/1

190 QC 5	50 pcs	4/13/20	0.00 0.00	Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
200 Packaging 3-1 - Stock - B4B	50 pcs 47	4/13/20	0.00 0.00	QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

DAS
81
9-89

APR 02 2020

DAS
80
9-89

APR 03 2020

					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
210 QC 21 - SA	47	50 pcs	4/13/20	0.00 0.00	QC 21 - SA - 21 ✓	LG050
					QC 21 - SA - 70	
					QC 21 - SA - 53	

DAS 21
APR 03 2020

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev 4B
 120 - (QC2- Inspect parts off machine FA/FAIB)
 130 - (QC8- Inspect parts - second check)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	15.4150 ft (.3083 ea)	100-Bandsaw - 1	S261 509
MS20426AD4-6	Rivet	300 Ea (6 ea)	180-Small Fab - 2 - B4B	S256493 S278334
MS21075L5	Nut Plate	150 Ea (3 ea)	180-Small Fab - 2 - B4B	S256564 X34 S267200

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.375X1.000	15	16	0
180-Small Fab - 2 - B4B	MS20426AD4-6	300	1,410	0
	MS21075L5	150	34	0

Part Specifications

Specifications could not be found.

Plex 3/20/20 8:34 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 208451
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.499	✓		Caliper	JCL-08
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	.750	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	.130	✓			
0.359	+/-0.010	.359	✓			
Ø0.316	+0.006/-0.001	0.320	✓			
1.000	+/-0.010	.998	✓			
0.250	+/-0.010	.250	✓			
0.061	+/-0.010	.060	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.229 x .130	✓			

Measured by: J.C.-L	Audited by: JKL	Prototype Approval: N/A
Date: 20-03-26	Date: 20/03/29	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					